Work Order I Thursday, September	D 73457 01, 2011 7:32:59 AM									Page 1
Item ID: D329 Revision ID:	93-1		Accept				s	Setup Star	1 1821681 6161	
Item Name: Doub Start Date: 8/31/ Required Date: 9/16/ Reference:	/2011 Start Qty: 8.0			Cust Item I Customer:	D:			Sto	P	
Approvals: Pro	ocess Plan:	Date: Date:	Tooling: _ SPC (Y/N):		ate:		F	Run Sta		
Sequence ID/ Work Center ID	Operation Description	10 April 10	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Insp. Stamp
Draw Nbr D3293	Revision Nbr Rev A							W		
Waterjet FLOW CNC Waterjet	FLOW WATER JE Memo 1-Cut Debur		0.00 :	入 □2-			B(1-	9-28	(8)	
QC Quality Control	QC2- Inspect parts	off machine FAI/FAIB	0.00				_(BII	<u>-9-59</u>		
120 QC	QC8- Inspect parts		0.00	10/28			(45)			

Quality Control

Duit AC	ospace	LU							
W/O:			WC	ORK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Dispositio	n:	QA: N/C CI	osed:		Date: _	
NCR:		,	WORK ORDI	ER NON-CONFORMA	NCE (NCR	(1)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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		•			-				
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Work Order ID 73457

Thursday, September 01, 2011 7:32:59 AM



Page 2

Item ID:

D3293-1

Revision ID:

Item Name:

Doubler

Start Date:

8/31/2011 **Required Date: 9/16/2011** Start Qty: 8.00 Req'd Qty: 8.00

Accept



Setup Start

Run

Stop

Reference:

Approvals:

Process Plan:

Date:

Date: _____

Tooling:

Date: Date:

Tool # Plan

Code

Cust Item ID:

Customer:

Tool ID

Accept

Qty



Reject

Qty

Insp.

Stamp

Reject

Number

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

140

Quality Control

Operation

Small Fab

Description

Memo

1- Debug

Set Up/ **Run Hours**

SPC (Y/N):

0.00

0.00

QC5- Inspect part completeness to step on W/O

0.00

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

Memo

0.00

8 SK 11-10-31.

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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							-		
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Ye	s No DQ	 A:	Date: _	
		esolution:							
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Sect Action Description	ion B		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng	Dat	se Sect	ion C	Chief Eng	QC Inspector
									

Work Order ID 73457

Page 3

Item ID:

Thursday, September 01, 2011 7:32:59 AM D3293-1

Accept

Accept

Qty

Setup Start

Stop

Revision ID:

Item Name:

Required Date: 9/16/2011

Doubler

8/31/2011

Start Otv: 8.00

Req'd Qty: 8.00

Cust Item ID:

Customer:

Tool ID

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Code

Stop

Reject

Number

Insp.

Stamp

Sequence ID/

Work Center ID

160

Powdercoat

Powder Coating

170

Quality Control

Operation Description

START TIME:

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

□OVEN TEMPERATURE:

0.00

Memo

QC3- Inspect Part Finish

0.00

Reject

Oty

COUNTED

180

Packaging

Packaging

Identify as per dwg & Stock Location.

Memo

0.00

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W/O:		,,,,,	WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Disposition	:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NC	₹)			
DATE	STEP	Description of NC			on B	Verifi	cation	Approval	Approval
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a		ion C	Chief Eng	QC Inspector
	·					,			
		. '							

Work Order ID Thursday, September 0												Page 4
Item ID: D329. Revision ID: Item Name: Double					Accept					Setup	Star Stop	
Start Date: 8/31/2 Required Date: 9/16/2 Reference:		Start Qty: 8.00 Req'd Qty: 8.00				Cust Item I Customer:	D:					1 14411181 81818 118 1181 1481
Approvals: Proc	cess Plan	:	Date:		Tooling: SPC (Y/N):		nte:			Run	Star Stoj	i 1881)199 BBUB 181 1186 1881
Sequence ID/ Work Center ID 190 QC Quality Control		Operation Description QC21- Final Inspection Memo	- Work Order Re	elease	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Re Qt	ject y	Reject Insp. Number Stamp

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W/O:			W	ORK ORDE	R CHANGES	3				
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	-						1		, , , , , , , , , , , , , , , , , , ,	
Part No	•	PAR #:	Fault Cate	gory:		NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Dispositio	n:		QA: N/C CI	osed:		Date: _	
NCR:	-		WORK ORD	ER NON-C	ONFORMAN	ICE (NCF	R)			
DATE	STEP	Description of NC		Corrective A			Verifi	cation	Approval	Approval
DATE	SIEP	P Description of NC Section A	Initial Chief Eng		Description lief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
			,	• .						
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						<u> </u>				

Thursday, September 01, 2011 7:32:57 AM

Work Order ID: 73457

Parent Item:

D3293-1

Parent Item Name: Doubler



Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP: □A□04.08.24□New issue□KJ/JLM□

IPP Rev:B Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	197.3000	1.8264	15.38021	1-9-79		
				Location		<u>Lo</u>	<u>Oty</u>	Loc Code					
				MAT022			197.3		·				
					105411		6		_			$/\circ$	\
				:	109424		4		_		•	1 %)
*					110347		0.5		_				
					112331		3		·			$\overline{}$	
					113796		7						
				-	114025		15.7						
				1	116604		5.8				•		
					117392		40.1						
					118180		115.2		1	1918			

W/O:			WO	RK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						•			
Part No	•	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:						Date: _	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCF	R)			
D.4.T.E.	0755	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	k Secti		Chief Eng	QC Inspector
		·							
	İ								

DART AEROSPACE LTD	Work Order:	73457
Description: Doubler	Part Number:	D3293-1
Inspection Dwg: D3293 Rev: A	· · · · · · · · · · · · · · · · · · ·	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

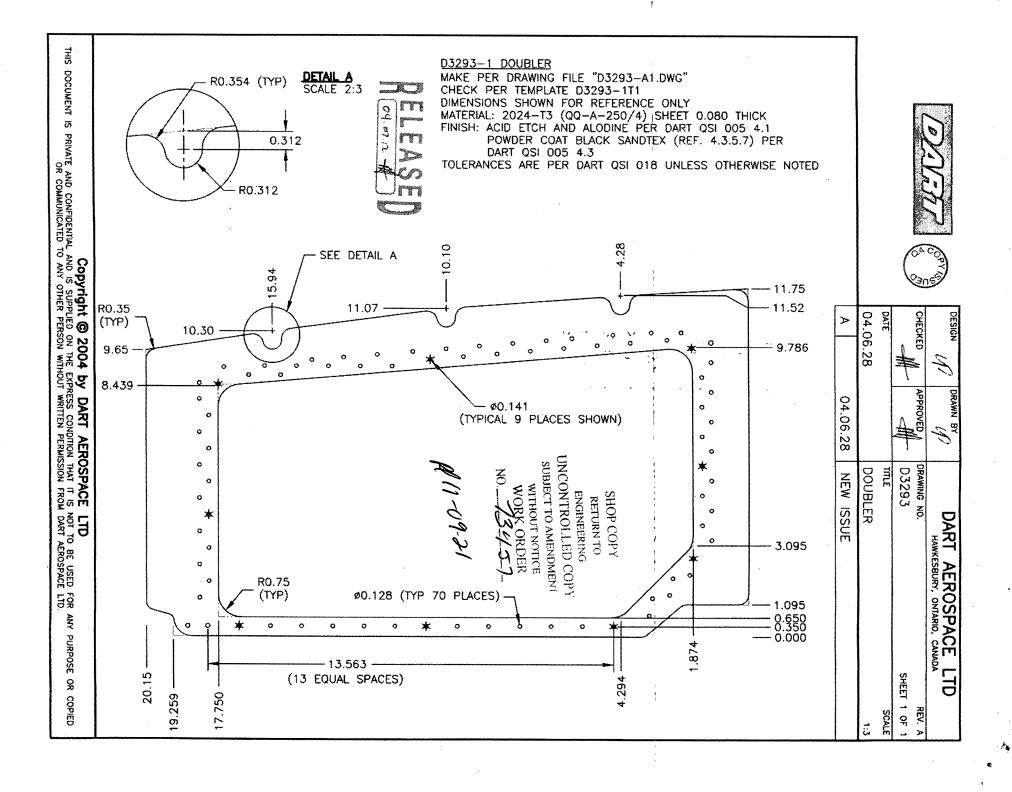
X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.350	+/-0.010	,348	مز		V 1302	
0.650	+/-0.010	.659	*		V	
1.874	+/-0.010	1.880	Э		V	
Ø0.141	+0.005/-0.001	.143	25		V	
Ø0.128	+0.005/-0.001	. ,31	0		V	
17.750	+/-0.010	17.750	×		7 BW	
20.15	+/-0.030	20.15	8	<u>.</u>	T	
R0.350	+/-0.010	350	x ee		RG	
R0.312	+/-0.010	-319	2		Ru	
0.080	+/-0.010	08c,	2		V	
						·

Measured by: (%	Audited by:	Prototype Approval:	N/A
Date: 11-9-29	Date: 41(0(75)	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.08.24	New Issue	KJ/JLM LA	
В	08.10.09	0.080 dimension added	KJ/DD	

		— - - -							
W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CHAN	EDURE CHANGE		Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			· · · - · · · · · · · · · · · · · · · ·						
							1		
Part No		PAR #:	Fault Categ	ory:	NCR: Yes	No DQA:	Date: _		
	R	esolution:	Disposition:		QA: N/C Clo	sed:	Date: _	Date:	
NCR:		. V	VORK ORDE	R NON-CONFORMA	NCE (NCR)		, , , , , , , , , , , , , , , , , , , ,		
DATE	ATE STEP	Description of NC Section A	Corrective Action Section B			Veriticatio		Approval	
DATE			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	n Approval Chief Eng	QC Inspector	
		•							



DATE STEP PROCEDURE CHANGE By Date Qty Chief	Approval General QC Inspector
Part No: PAR #: Fault Category: NCR: Yes No DQA: D	ate:
Resolution: Disposition: QA: N/C Closed: D	ate:
NCR: WORK ORDER NON-CONFORMANCE (NCR)	
DATE STED Description of NC Corrective Action Section B Verification App	roval Approval
	ef Eng QC Inspector